

Work Order ID 158284

Friday, March 17, 2017 9:11:17 AM

158284

Page 1

Item ID: D412-698-031

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Cabin Door Roller LH Composite Door

Start Date: 3/20/2017 Start Qty: 1.00

Required Date: 3/21/2017 Req'd Qty: 1.00

Reference: SCHEDULED/C

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

MAR 17 2017

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN D412-698

F

DAS
6
9-89

MAR 16 2017

DAS
21
9-89

1703-17

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D412-698-031

CHG002

DAS
27
9-89

MAR 21 2017

②

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

①

DAS
6
9-89

MAR 16 2017

DAS
28
9-89

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS
27
9-89

MAR 21 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER :				
Misidentified ☐	☐	Past Due ☐					

Work Order ID 158284

Friday, March 17, 2017 9:11:17 AM

158284

Page 2

Item ID: D412-698-031 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Cabin Door Roller LH Composite Door
Start Date: 3/20/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/21/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: SCHEDULED/C

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-698-031								
Packaging	Locaiton : FG034 <u> </u> <i>sold</i>								
140	QC21- Final Inspection - Work Order Release	0.00							
140	Memo	0.00							
QC									
Quality Control									

DAS
DAS28
27 2-89
9-89

MAR 21 2017

DAS
21
9-89

MAR 21 2017

MAR 21 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐								
Misidentified	☐	Past Due	☐								
				OTHER :							

Picklist Print

Friday, March 17, 2017 9:11:22 AM

Page 1

Work Order ID: 158284

158284

Parent Item: D412-698-031

D412-698-031

Parent Item Name: Cabin Door Roller LH Composite Door

Start Date: 3/20/2017

Required Date: 3/21/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 08.07.03 EC verified by:LL
16.07.28 IIN REV.F DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3121-143 *D3121-143* Bracket Assembly		Manufactured	No			110	Each	2.0000	1	1			DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST018				2					
					148060			2		1			
D3202-3 *D3202-3* Cover		Manufactured	No			110	Each	9.0000	1	1			DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST195a				9					
					148198			1					
					148300			8		1			
D3674-041 *D3674-041* Roller Bracket Assembly		Manufactured	No			110	Each	39.0000	3	3			DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST050				39					
					143720			39		3			
D3674-043 *D3674-043* Roller Bracket Assembly		Manufactured	No			110	Each	4.0000	1	1			DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST050				4					
					156951			4		1			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER :						
Misidentified ☐	☐	Past Due ☐							

Picklist Print

Friday, March 17, 2017 9:11:22 AM

Page 2

Work Order ID: 158284

158284

Parent Item: D412-698-031

D412-698-031

Parent Item Name: Cabin Door Roller LH Composite Door

Start Date: 3/20/2017

Required Date: 3/21/2017

Start Qty: 1.00

Required Qty: 1.00

D3674-045

Manufactured No

110

Each

4.0000

1

1

D3674-045

Roller Bracket Assembly

DAS
6
9-89

MAR 16 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

ST050

4

150040

4

D3675-1

Manufactured No

110

Each

31.0000

9

9

D3675-1

Sliding Door Bracket

DAS
6
9-89

MAR 16 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

ST051

31

148408

11

149599

20

DAS
27
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

8.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 412-030-300-XXX COMPOSITE DOORS)

Qty -019	Qty -021	Qty -031	Qty -032	Qty -033	Qty -035	Qty -037	Qty -038	Part Number	Description
X								D412-698-019	BEARING OVERHAUL KIT
	X							D412-698-021	REPLACEMENT SHIM KIT
		X						D412-698-031	CABIN DOOR ROLLER KIT, LH
			X					D412-698-032	CABIN DOOR ROLLER KIT, RH
				X				D412-698-033	REPLACEMENT DOOR TRACK KIT
					X			D412-698-035	DOOR HANDLE KIT
						X		D412-698-037	BRACKET KIT, LH (COMPOSITE DOORS)
							X	D412-698-038	BRACKET KIT, RH (COMPOSITE DOORS)
7								D3121-21	BOLT
5								D3121-241	BEARING ASSEMBLY
1								D3137-3	GUIDE
1								D3137-5	WASHER
2								D3183-045	BEARING ASSEMBLY
	3							D3238-1	SHIM
	1							D3238-3	SHIM
	2							D3238-5	SHIM
	6							D3238-11	SHIM
	2							D3238-13	SHIM
	4							D3238-15	SHIM
		1						D3121-143	BRACKET ASSEMBLY
			1					D3121-144	BRACKET ASSEMBLY
		1	1	1				D3202-3	COVER
		3	3					D3674-041	BRACKET ASSEMBLY
		1						D3674-043	ROLLER BRACKET ASSEMBLY
			1					D3674-044	ROLLER BRACKET ASSEMBLY
		1	1					D3674-045	ROLLER BRACKET ASSEMBLY
		9	9	9				D3675-1	BRACKET
						1		D3675-5	FORWARD BRACKET, LH
							1	D3675-6	FORWARD BRACKET, LH
					2			D3779-041	HANDLE ASSEMBLY
					2			D3779-3	PLATE
					2			D3779-043	HANDLE ASSEMBLY
					12			AN525-832R8	SCREW
					12			NAS1149D0332J	WASHER (AN960JD10L)
					12			MS21042L3	NUT
					12			MS24694-S51	SCREW
1								MS24694-S101	SCREW